

Work Order ID 64366

December 2, 2010 2:48:11 PM

Handwritten signature

Dec 6



Page 1

Item ID: D3340-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Skidtube Protector

Start Date: 12/02/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3340

Rev B

0.00

1810-12-3

100



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3340 Dwg Rev: *B* Prog Rev: *B* 2-
Deburr if necessary

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

1810-12-3



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

81012/03

(74)

Work Order ID 64366

December 2, 2010 2:48:11 PM

Page 2

Item ID: D3340-13

Accept

Revision ID:

Item Name: Aft Skidtube Protector

Start Date: 12/02/10 Start Qty: 4.00

Required Date: 12/06/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT 8326 and DT8261

0.00

0.00

SA 10/12/06

(4)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SA 10/12/06

(4)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

16:20

OVEN TEMPERATURE:

3200

FINISH TIME:

10:50

0.00

0.00

4 10-12-06

Work Order ID 64366

December 2, 2010 2:48:12 PM



Page 3

Item ID: D3340-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Skidtube Protector

Start Date: 12/02/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

=) Jll

10/12/06

4 0

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 820

0.00



Packaging

Memo

0.00

Packaging

10/12/10 (G)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/07 J
u 10.12.06

Picklist Print

December 2, 2010 2:48:10 PM

Page 1

Work Order ID: 64366

Parent Item: D3340-13

Parent Item Name: Aft Skidtube Protector



Start Date: 12/02/10

Required Date: 12/06/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC
IPP Rev:B Now on Waterjet 06-10-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No			110	sf	79.3000	1.258	5.296842			



1010/1025 SHEET



B10-12-3

④

Location

Loc Qty

Loc Code

MAT

79.3

111410

79.3

111410

DART AEROSPACE LTD		Work Order: 64366
Description: Aft Skidtube Protector		Part Number: D3340-13
Inspection Dwg: D3340 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

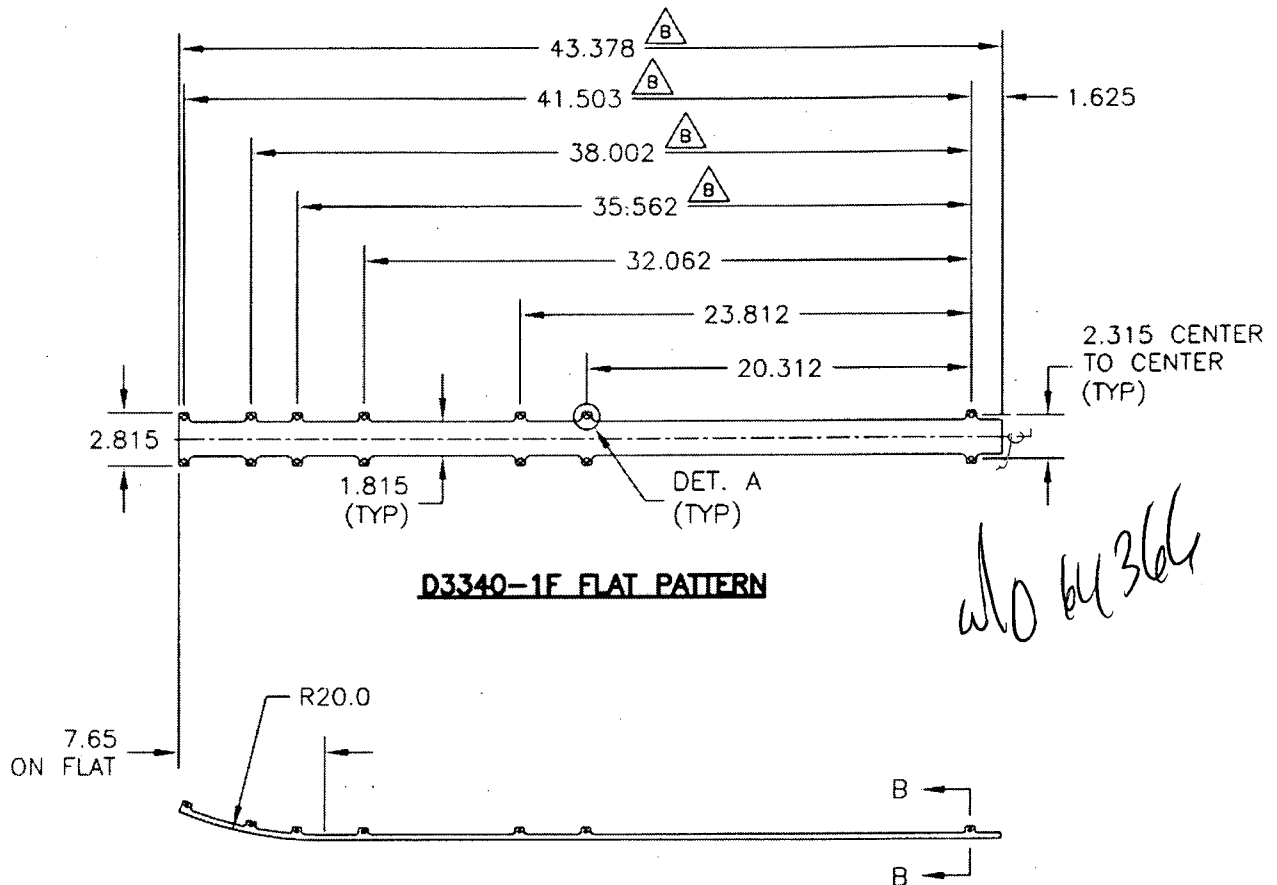
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0.300	+/-0.010	.304	X		V	
0.50	+/-0.030	.495	X		V	
0.250	+/-0.010	.250	X		V	
2.315	+/-0.010	2.312	X		V	
2.815	+/-0.010	2.819	X		V	
1.625	+/-0.010	1.625	X		V	
23.125	+/-0.010	23.125	X		T 1B01	
26.625	+/-0.010	26.625	X		T	
52.315	+/-0.010	52.315	X		T	
55.815	+/-0.010	55.815	X		T	
58.190	+/-0.010	58.190	X		T	
61.000	+/-0.010	61.000	X		T	
63.565	+/-0.010	63.565	X		T	
0.040	+/-0.010	.037	X		V	

Measured by: B	Audited by: D	Preliminary Approval:
Date: 10-12-3	Date: 10/12/03	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	

DART**RELEASED**
05.11.28

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 1 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10
A	05.06.09	NEW ISSUE	
B	05.11.22	ADD DETAIL D, CORRECT FLAT PATTERNS D3340-1/-3/-7/-9/-13/-19/-23	

**NOTES:**

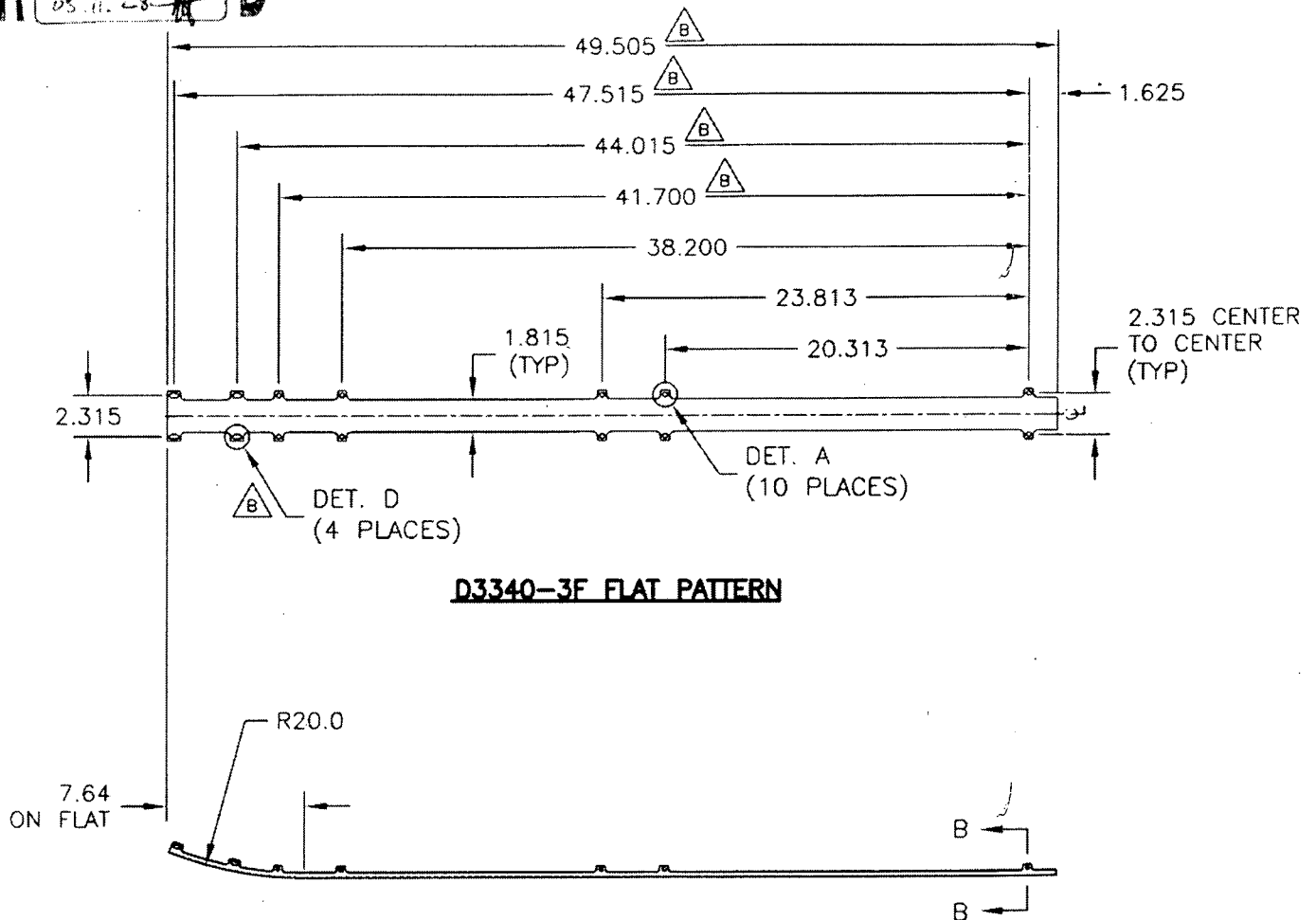
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- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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05.11.28 *[Signature]***NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
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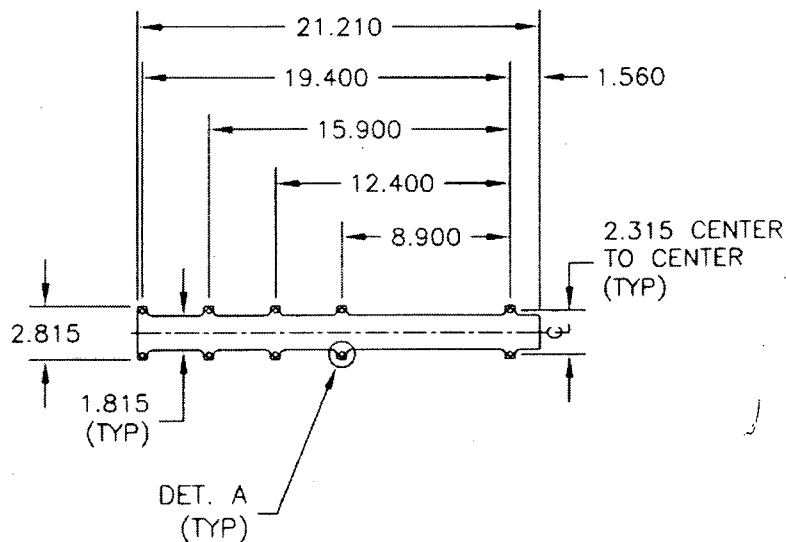
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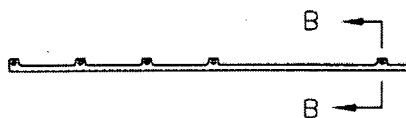


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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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D3340-5F FLAT PATTERN



D3340-5 FORWARD SKIDTUBE PROTECTOR

NOTES:

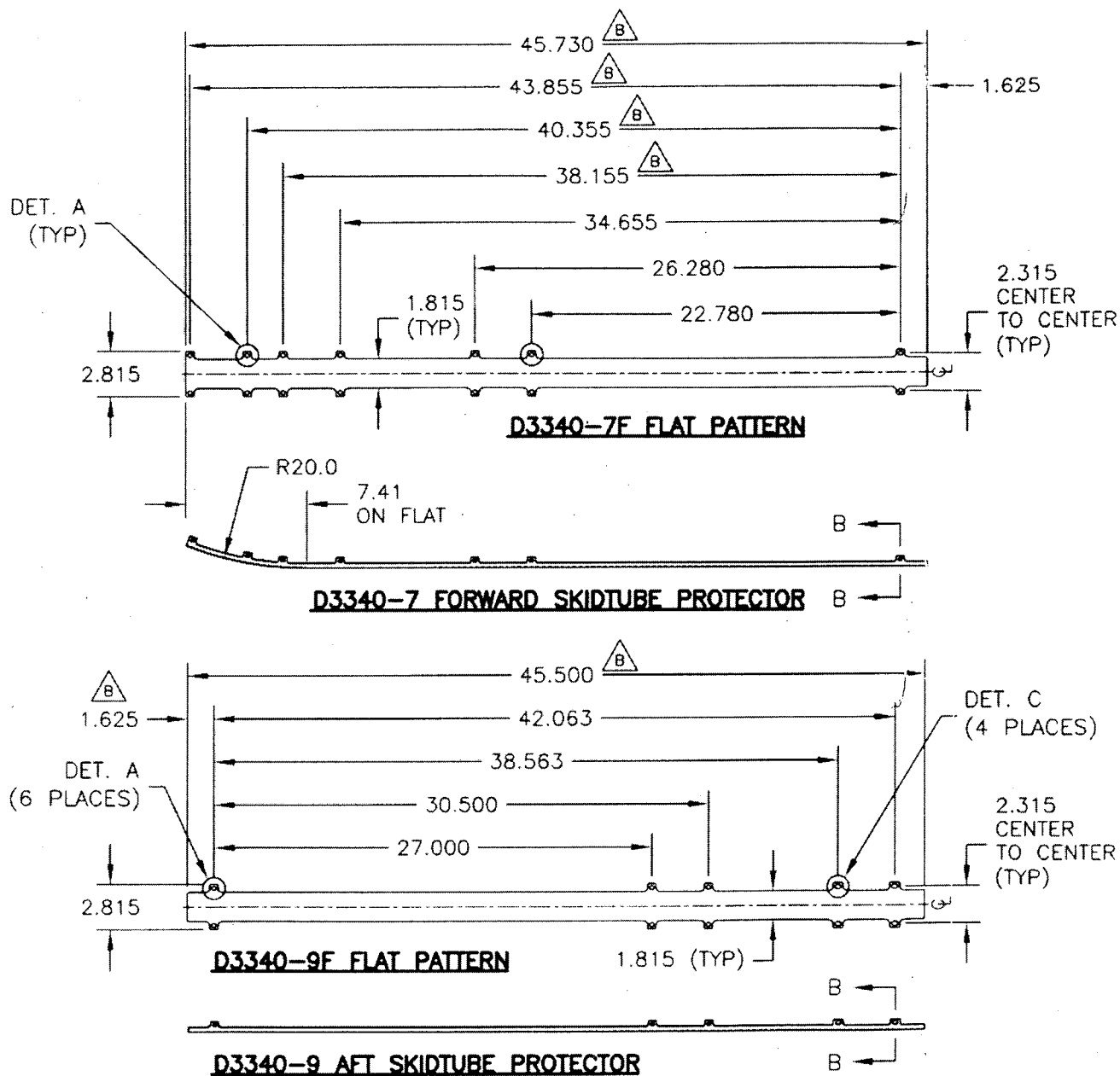
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- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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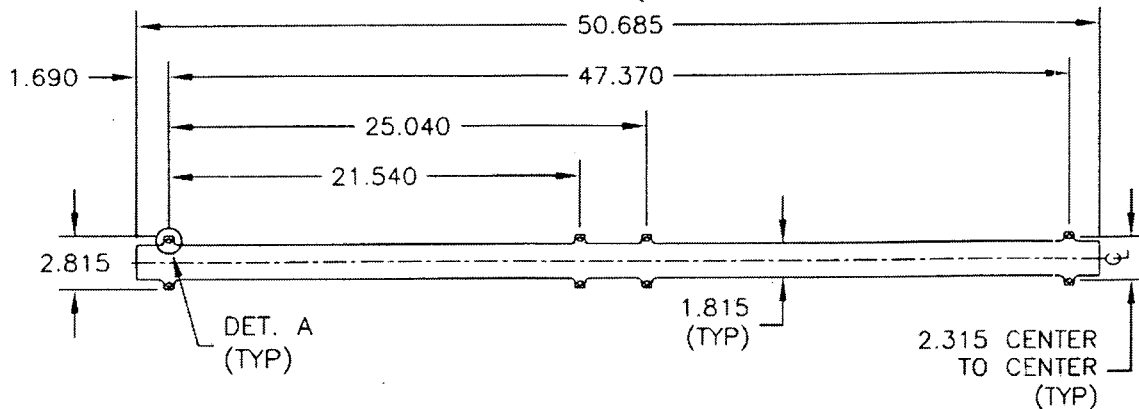
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05 11 28

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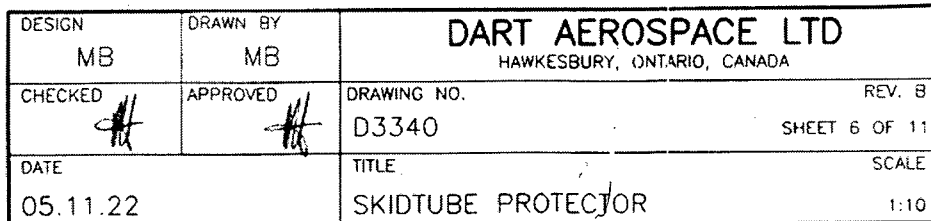
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

RELEASED
05.11.22**D3340-11F FLAT PATTERN****D3340-11 CENTER SKIDTUBE PROTECTOR****NOTES:**

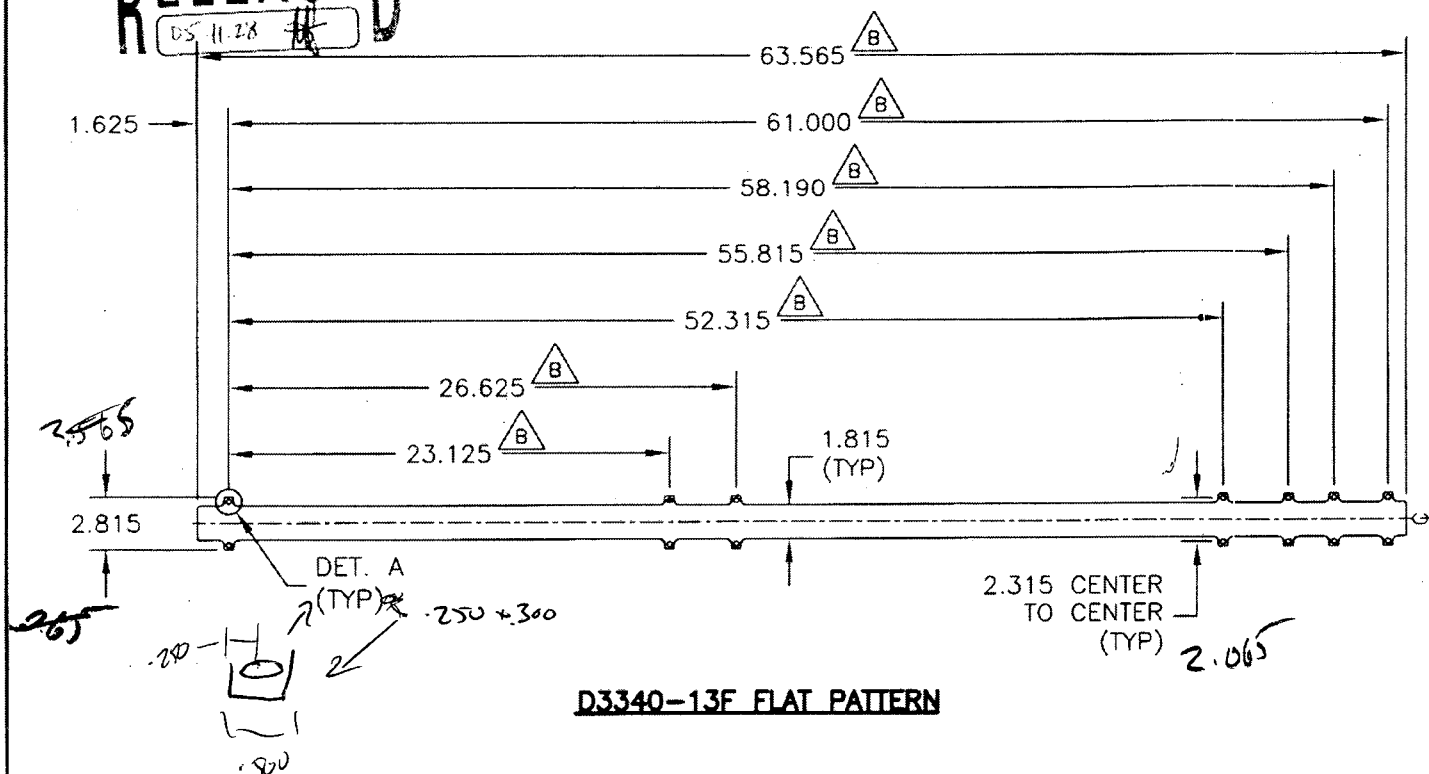
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ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
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- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
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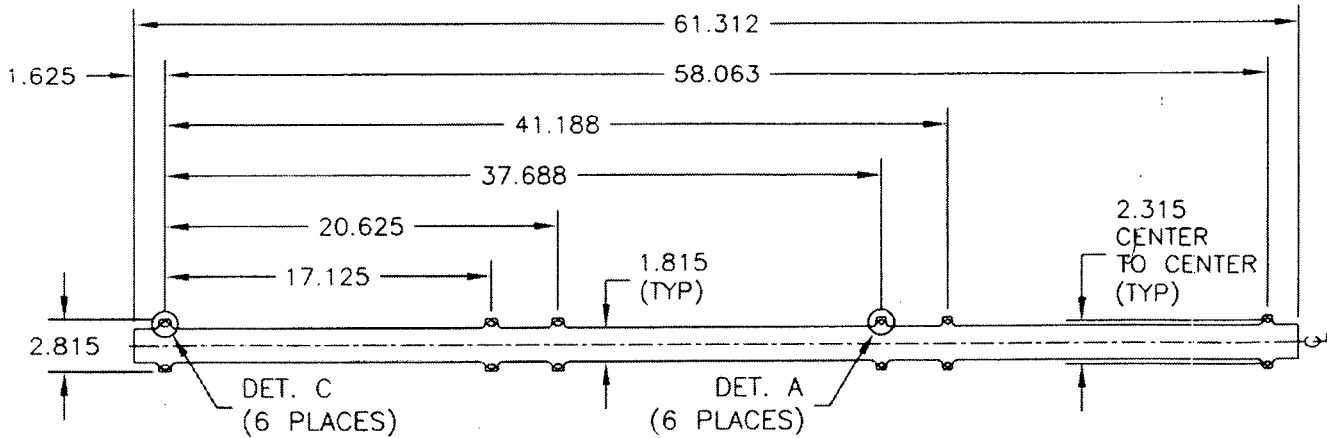
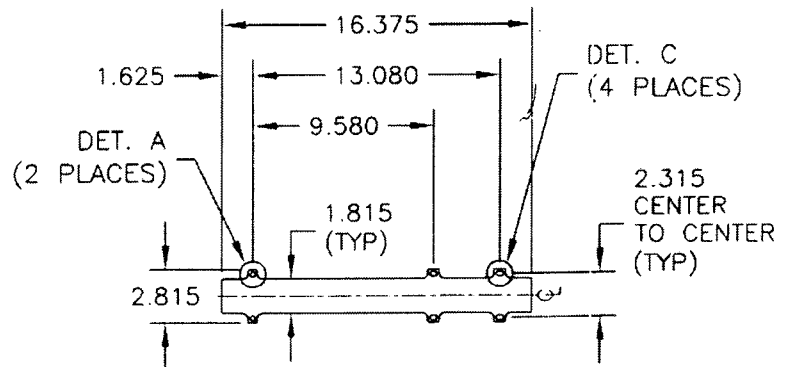
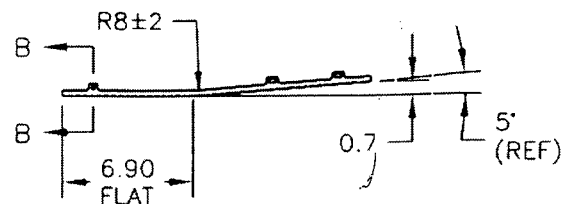
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CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

**D3340-15F FLAT PATTERN****RELEASED**
05.11.22 *[Signature]***D3340-15 CENTER SKIDTUBE PROTECTOR****D3340-17F FLAT PATTERN****D3340-17 AFT SKIDTUBE PROTECTOR****NOTES:**

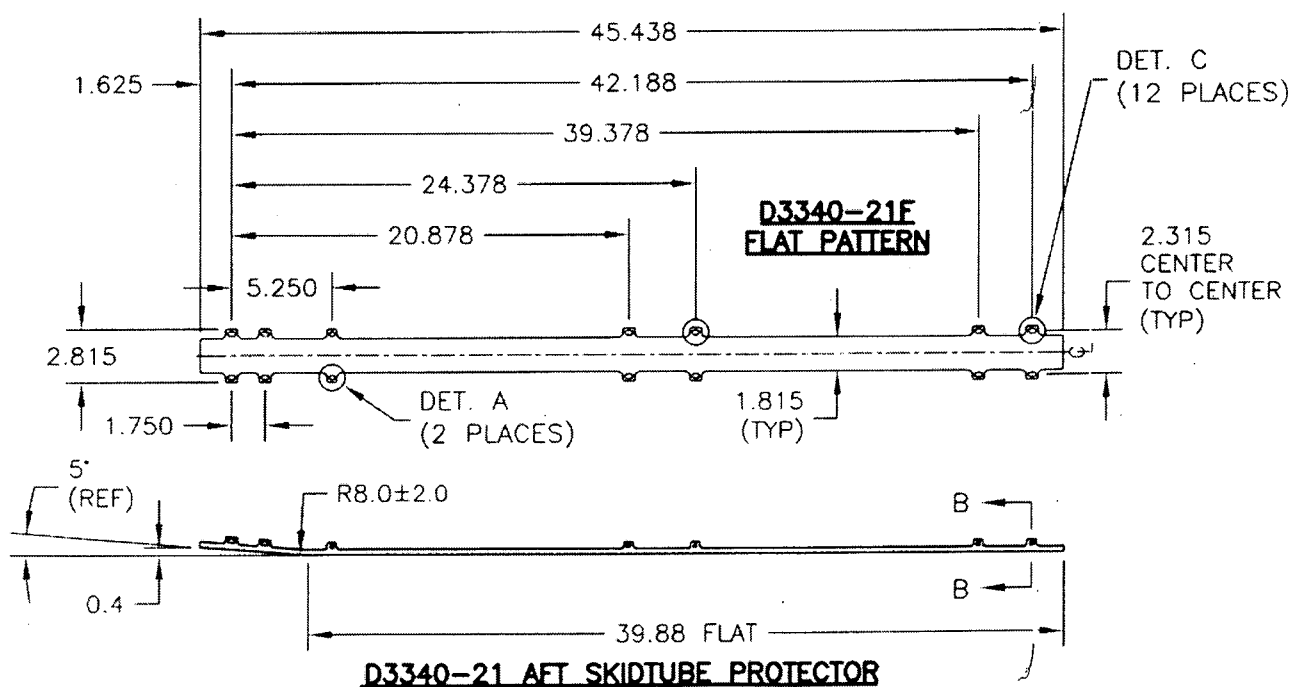
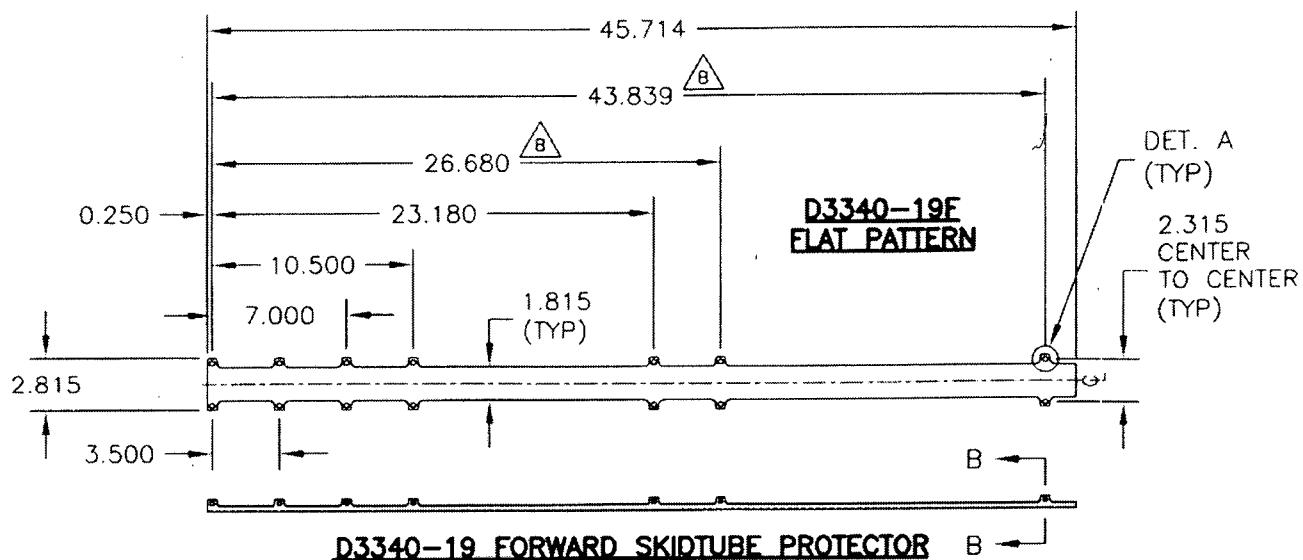
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ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W
SERIES COLD ROLLED STEEL 19 GAUGE
(0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX
(REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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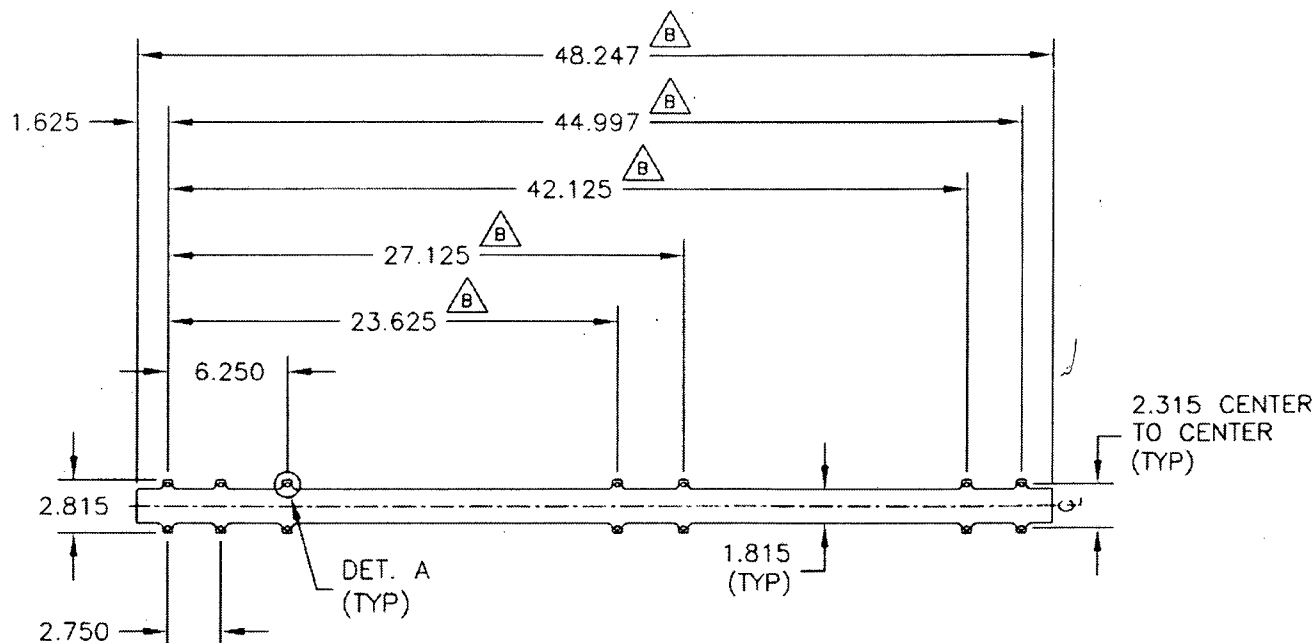
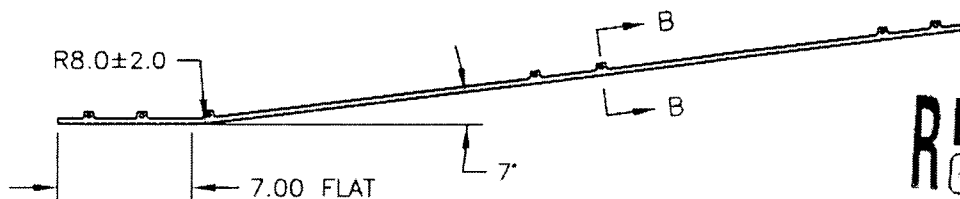
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CHECKED H	APPROVED H	DRAWING NO. D3340	REV. B SHEET 9 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10

**D3340-23F FLAT PATTERN****D3340-23 AFT FLOAT SKIDTUBE PROTECTOR****NOTES:**

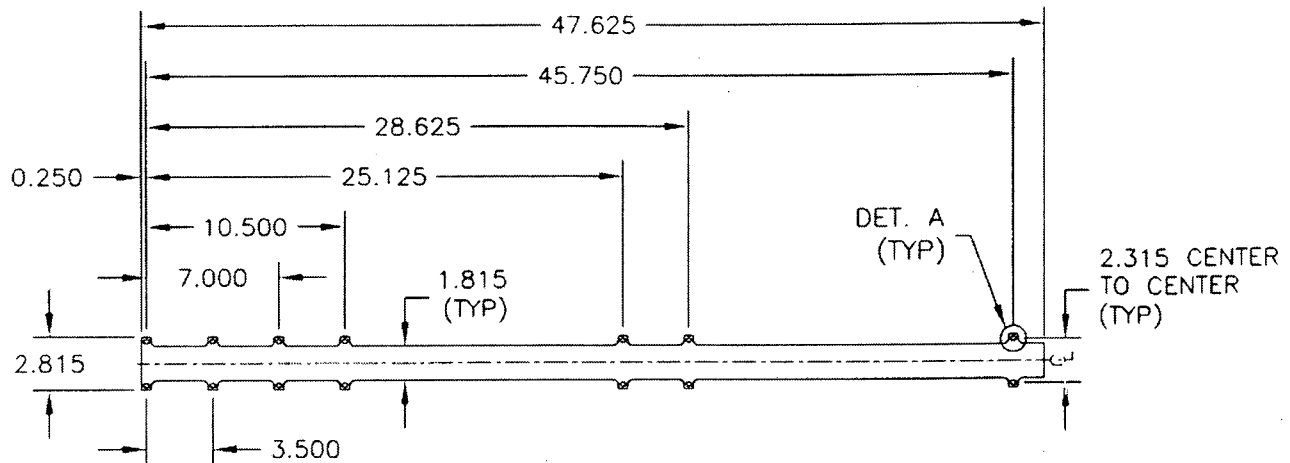
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ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 10 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

**D3340-25F FLAT PATTERN****RELEASED**
05.11.28**D3340-25 FORWARD SKIDTUBE PROTECTOR****NOTES:**

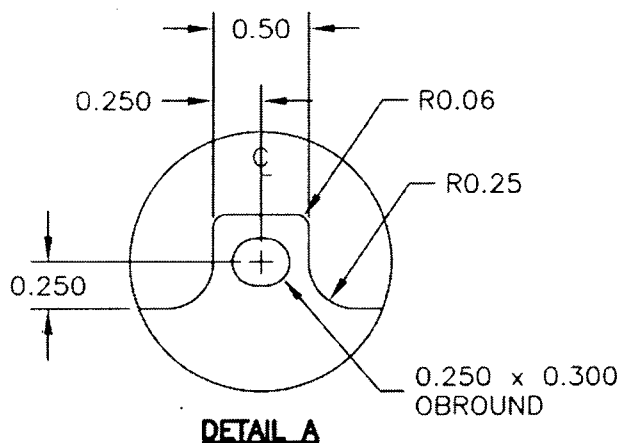
- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
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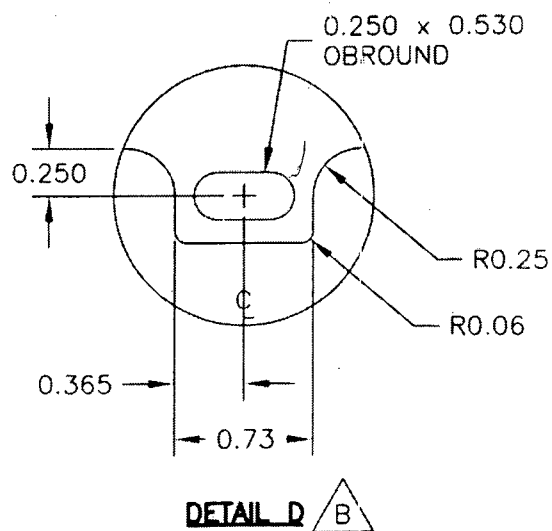
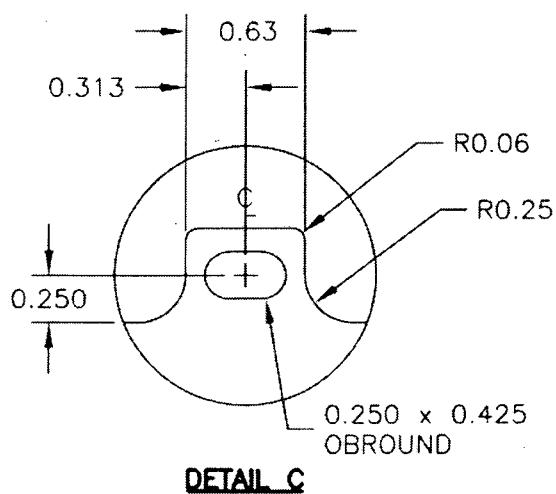
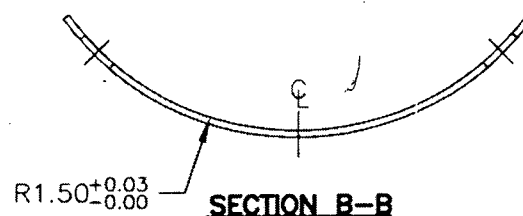
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



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